

Date: Wednesday, 04/06/2008 1:53:42 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MIRROR ARM LONG (S-76)		
Job Number	: 39700			Part Number	: D2261	
Estimate Number	: 11893			Drawing Number	: D2261 REV A1	
P.O. Number	:			Project Number	: N/A	
This Issue	: 04/06/2008	S.O. No.	:	Drawing Revision	: A1	
Prsht Rev.	: NC			Material	:	
First Issue	: 04/06/2008	Type	: SMALL /MED FAB	Due Date	: 11/06/2008	Qty: 5 Um: Each
Previous Run	: 33329					
Written By	:					
Checked & Approved By	: <u>JUL 08.6.04</u>					
Comment	: Est: D 02.04.15 Added dwg Rev.A1 NG					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 3.1281 f(s)/Unit Total : 15.6403 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall (M304TR0500W035) Batch No: M108215	SB 08/06/05 (S)
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch tube 304/316 with 2B finish Form as per dwg D2261 Deburr	SR 08/06/05 FF 08-06-12 EB08/06/09 (S)
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	08/06/12 (S)
4.0	POWDER COATING	POWDER COATING	
			 M102316
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	5X
		START TIME: <u>11:00 am</u>	
		OVEN TEMPERATURE: <u>320 °F</u>	
		FINISH TIME: <u>11:30 am</u>	
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
		Comment: INSPECT POWDER COAT	FF 08/06/12 (S)

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Drawing Name: MIRROR ARM LONG (S-76)

Job Number: 39700

Part Number: D2261

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
4	D2022-101	Spacer	137621

7.0 A1449

Grommet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Grommet

Pick:

Qty	Part Number	Description	Batch
2	A1449	Grommet	14872

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2261

RF 08-06-17

(5)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/17 (5)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

STO29

PCP/20 (5)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-06-20

Job Completion



**DART**

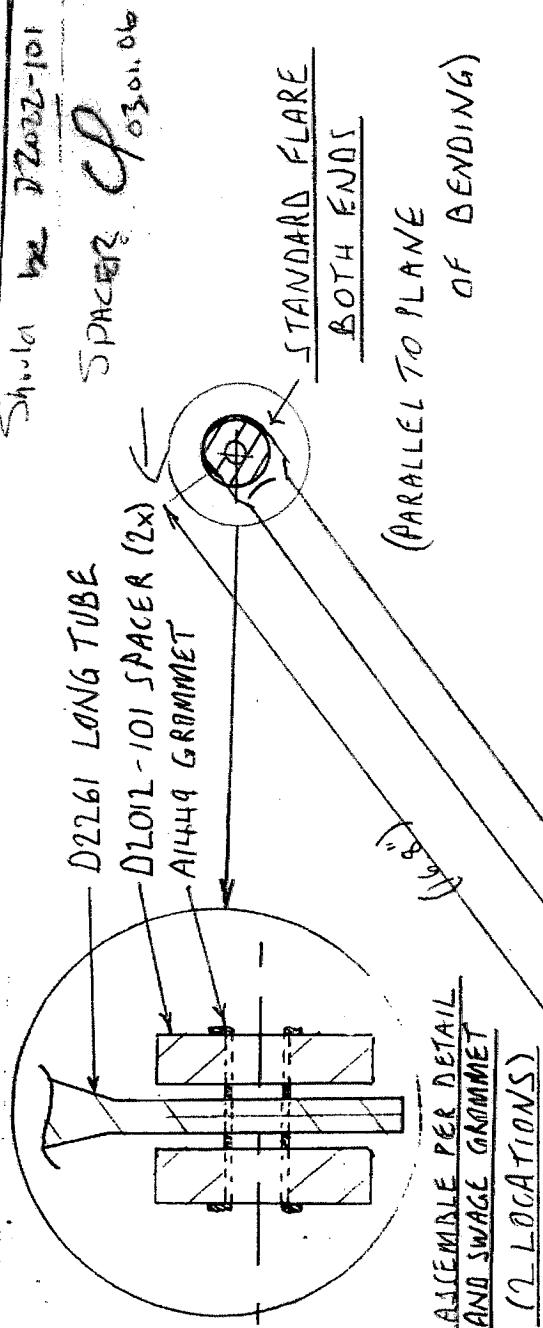


DRAWN M. Cohn. DART AERO ACCESSORIES INC  
DESIGN VICTORIA INTERNATIONAL AIRPORT, CANADA  
DRAWING NO. D2261 REV. A  
SHEET 1 OF 1

Aug 10/94 TITLE LONG TUBE

A1 ~~0203.22~~ ADD FINISH

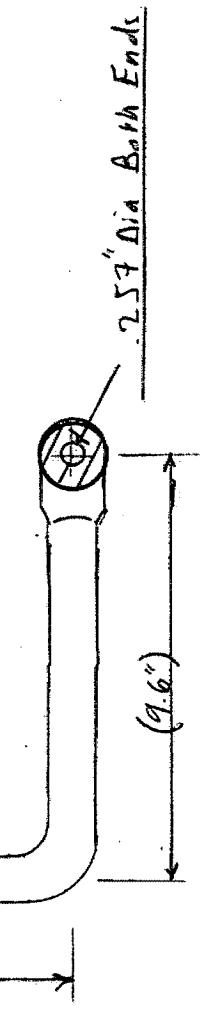
Should be D222-101



MATL: 304SS  $\frac{1}{2}$ " OD x .035" WALL TUBE  
FINISH: POLISHED COAT BLACK SANDTEX (4.3.5.7)  
PER DART GS-1051 rev. 4.3 A1

PROCEDURE:

1. TOTAL TUBE LENGTH = 35.75"
2. STANDARD FLARE BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.
  - FEED THRU //, BEND 90°
  - FEED THRU 19  $\frac{3}{4}$ " (TOTAL), BEND 60°



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WORK ORDER  
NO. 31900

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries